

Work Order ID 144763

Friday, May 06, 2016 11:41:24 AM

144763

Page 1

Item ID: D4125-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Sediment Bowl

Start Date: 5/11/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/25/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4125	D								

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1-Cut Blank at 6.500"

6 0 16-07-29

105

1.36

105

HAAS 1

Memo

2.76

HAAS CNC vertical machine #1

Machined as per folio FB079

Rev: AADwg: D

Deburr

6 0 16-7-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					

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Page 3

Item ID: D4125-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Sediment Bowl

Start Date: 5/11/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/25/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.12

Quality Control

B. = 16/08/04

6

Ø

DAS
08
9-89

150

Identify as per dwg & Stock Location: W403

0.00

150

Packaging

Memo

0.06

Packaging

LOCATION: WA003

6x 21 6 sept 2016

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.60

Quality Control

DAS
21
9-89

SEP 06 2016

DAS
21
9-89

SEP 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

Friday, May 06, 2016 11:41:24 AM

Page 1

Work Order ID: 144763

144763

Parent Item: D4125-3

D4125-3

Parent Item Name: Aft Sediment Bowl

Start Date: 5/11/2016

Required Date: 5/25/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.07.21 new issue DD verf:EC
11/12/05 as per rev.B JFS verf:DD
remove alodine and add holes DD VERF:JLM

IPP Rev:B
IPP REV:C 15.03.04

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X08.00 0		Purchased		No		100	f	14.8950	0.542	3.423158			

M6061T6B2 000X08 000

6061-T6 BAR 2.00' X 8.00" (CUT IN 4FT SECTION)

Location

Loc Qty

Loc Code

MAT007

14.895

m127095

0.596

m132693

2.299

m132772

4

m134495

8

M134776

3.43

P16-07-29

DQA: _____ Date: _____

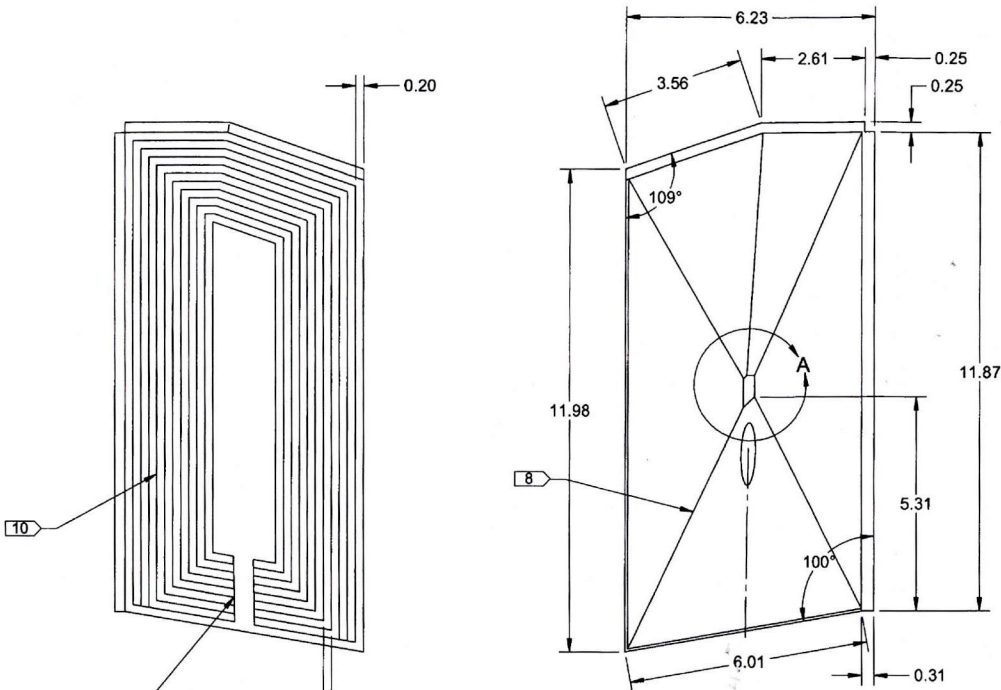


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QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																																																																					



NOTES:

1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 REF DART SPEC M6061T6B1.750X6.250

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.25 lbs
- 8) MAXIMUM INSIDE RADIUS = 0.250
- 9) MINIMUM RADIUS = 0.187
- 10) MINIMUM RADIUS = 0.015

D4125-1 FWD SEDIMENT BOWL

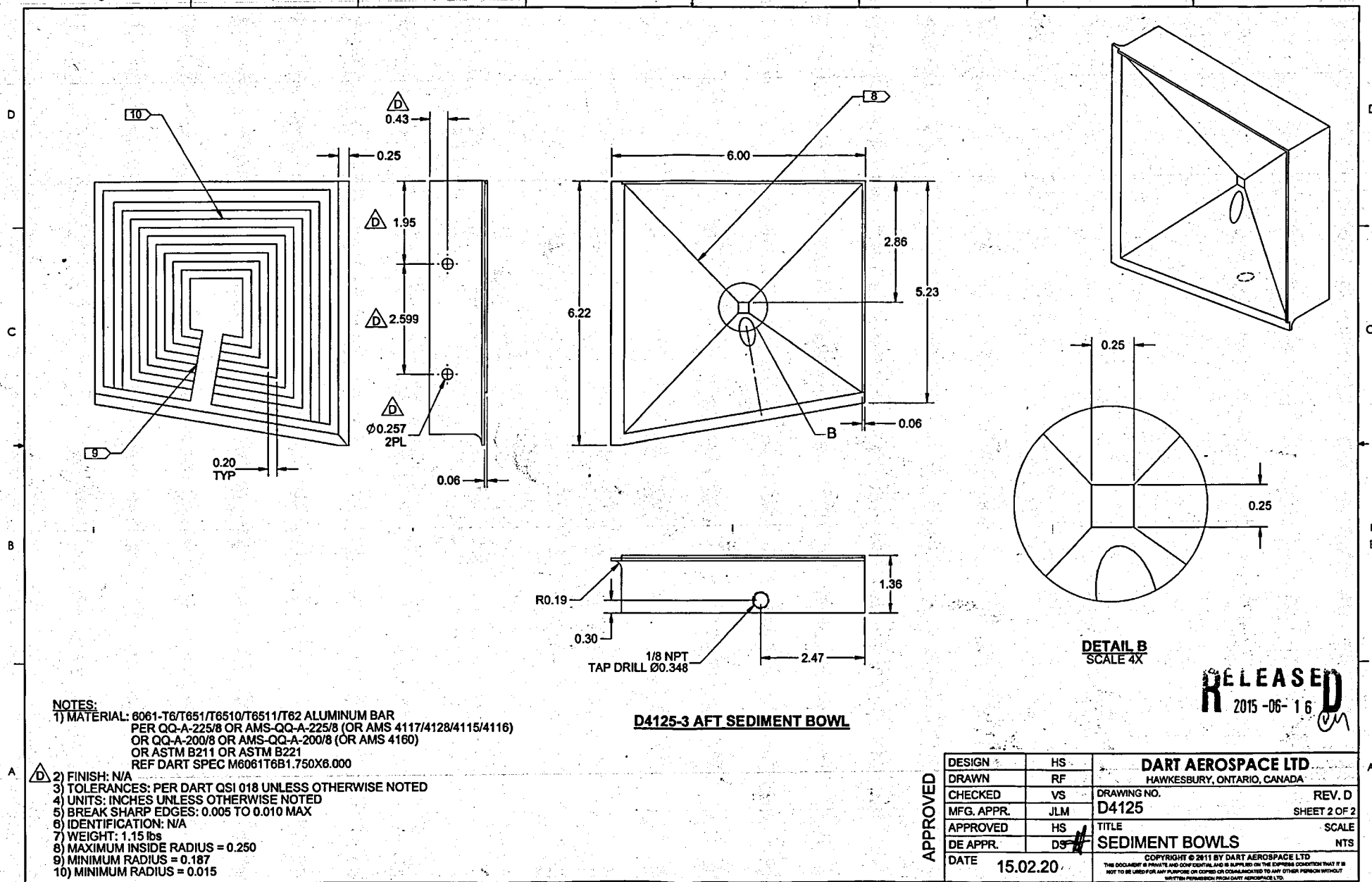
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 144763 MJS
 16-0505

DETAIL A
 SCALE 4X

RELEASED
 2015-06-16
 ECN 15-583

D	ADDED MOUNTING HOLES TO THE -1/3 SEDIMENT BOWLS; FINISH NOW COMPLETED AT NEXT ASSEMBLY	CC	15.02.20
C	MODIFY DESIGN OF -1/3: ADD PERIMETER WALL, CREATE EQUAL STEPS.	DC	11.11.29
B	MODIFY DESIGN OF -1/3, REMOVED -041	DC	11.09.29
A	NEW ISSUE	HS	10.07.26
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4125	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SEDIMENT BOWLS	NTS
DATE	15.02.20	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1